

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026445**Date Inspected:** 01-Oct-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA performed observation at random intervals of approved ABF welding personnel performing fit-up and Shielded Metal Arc Welding (SMAW) of temporary attachments at the "A" deck plates and "D" bottom plates of 12E/13E and 12W/13W segment splices.

At these temporary attachment locations this QA has observed arc strikes outside the weld joint at various locations on both the Lift 12 (non SPCM material) and the Lift 13 (SPCM material) sides of these segment splices. Attached to this report are photographs of typical examples of observed arc strikes.

This QA also observed during adjustment of the temporary fitting aids ZPMC personnel broke loose a fitting lug that was welded to the deck. This was after repeated hammer blows to the adjustment pin portion of the fitting aid. ZPMC personnel ground flush the remaining portion on the broken fillet weld that was still attached to the "A" deck, preheated the area, and re-welded the fitting lug onto the previous location.

At this time, this QA has not been presented with approved Welding Procedure Specification's (WPS') for the welding of these temporary attachments.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract

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# WELDING INSPECTION REPORT

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documents.



## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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**Inspected By:** Clifford, William

Quality Assurance Inspector

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**Reviewed By:** Levell, Bill

QA Reviewer